

~~PRELIMINARY ISSUE~~

Page 1

Work Order ID 70212

Tuesday, May 31, 2011 11:38:21 AM



Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:



Reference:

Approvals:

Process Plan: *R*Date: *11-05-31*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4308	A
IIN-D206-628	<i>PGT G</i>

100

0.00



DC

Memo

0.00

Document Control

Photocopy bluefile & type labels per PPP D206-628-026
CHG 001*Sublet
to Rev G IIN*

110

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

11/6/7 SP 12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 70212

Page 2

Tuesday, May 31, 2011 11:38:21 AM

Item ID: D206-628-026BL

Accept



Setup Start



Revision ID: PRELIM

Stop



Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 6/15/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

220

QC4- 100% Inspct kits for completeness

0.00



QC

Memo

0.00

Eulobler
to REG 11

Quality Control

230

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

DRAFT

Packaging

Package per PPP D206-628-026

11/6/8 @

240

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

11/6/9

Quality Control

MF 11-06-08

POSITIVE RECALL

EFFECTIVE 11/5/11 AUTH 11

RELEASED 11/6/11 DATE 11.06.06

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Tuesday, May 31, 2011 11:38:26 AM

Page 1

1. The first step in the process is to identify the problem. This involves gathering information about the situation and the people involved.

2. The second step is to analyze the problem. This involves breaking the problem down into smaller parts and understanding the causes.

3. The third step is to develop a plan. This involves deciding on the best way to solve the problem and setting goals.

4. The fourth step is to implement the plan. This involves putting the plan into action and making changes as needed.

5. The fifth step is to evaluate the results. This involves checking to see if the problem has been solved and if the goals have been met.

6. The sixth step is to reflect on the process. This involves thinking about what worked well and what could be improved.

7. The seventh step is to share the results. This involves telling others about what you have learned and how you solved the problem.

8. The eighth step is to continue to learn. This involves staying open to new ideas and ways of solving problems.

9. The ninth step is to be a good team player. This involves working well with others and helping them to solve their problems.

10. The tenth step is to be a good leader. This involves helping others to solve their problems and making sure everyone is working together.

1. The first step in the process is to identify the problem or issue that needs to be addressed. This involves gathering information and understanding the context of the problem.

Required Qty: 2.00

[illegible]

Part Number	Description	Material	Quantity	Unit	Price	Location	Loc Qty	Loc Code	Notes
D4308-042	Step, RH Crew	Manufactured	No	Each	0.0000	139e	20		+1 2 B70120 SP
D2731-7RG	Mounting Lug	Manufactured	No	Each	0.0000	139e	4		+2 4 B70118 SP
D3394-3RG	Lug	Manufactured	No	Each	0.0000	139e	4		+2 4 B70119 SP
D4309-1	Bushing	Manufactured	No	Each	20.0000	139e	4		+2 4 SP
AN4-11A	Bolt	Purchased	No	Each	298.0000	70099	20		+4 8 116/7 SP (2)

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
139e	20	
70099	20	

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST356	100	
117872	100	
ST357	198	
110382	1	
115316	197	

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

Picklist Print

Tuesday, May 31, 2011 11:38:27 AM

Page 2

Work Order ID: 70212

Parent Item: D206-628-026BL

Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

AN4-12A

Purchased

No

Each

213.0000



Bolt

Location

Loc Qty

Loc Code

ST357

213

115422

113

117508

100

AN4-15A

Purchased

No

Each

391.0000



Bolt

Location

Loc Qty

Loc Code

ST308

6

116786

6

ST357

200

117423

200

ST358

185

117794

34

117854

51

117872

100

MS21042-4

Purchased

No

Each

252.0000



USE MS21042L4

Location

Loc Qty

Loc Code

ST299

252

100743

9

5389

78

5461

3

6844

19

7690

24

8182

115

9229

4

Tuesday, May 31, 2011 11:38:27 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

Page 3

Tuesday, May 31, 2011 11:38:27 AM

Work Order ID: 70212



Parent Item: D206-628-026BL



Parent Item Name: Crew Step, RH, Blue

Start Date: 5/31/2011

Required Date: 6/15/2011

Start Qty: 2.00

Required Qty: 2.00

NAS1149D0463J

Purchased

No

Each

3,635.000



Washer



12
11/6/11 JD (20)

Location

Loc Qty

Loc Code

FP-B

8

116805

8

ST298

3627

116025

26

116805

0

117291

1001

117460

1600

117591

1000

12

Tuesday, May 31, 2011 11:38:27 AM

Shop Packet Print

Page 3

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

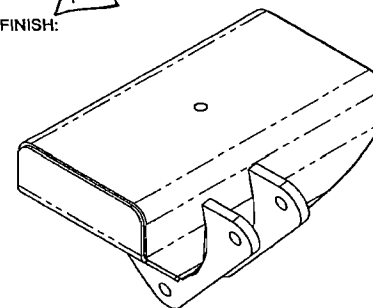
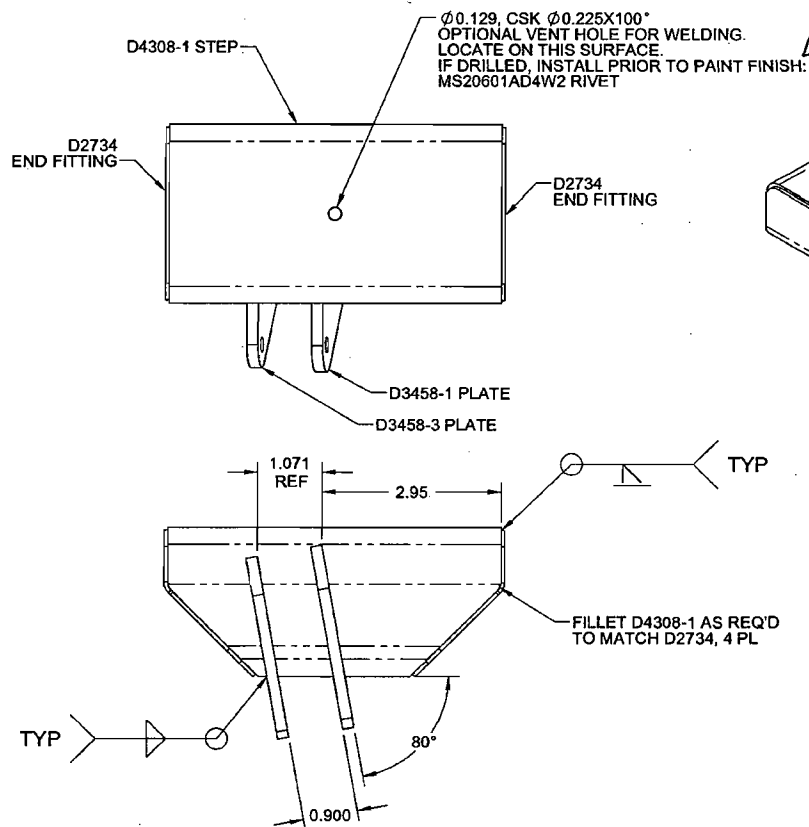
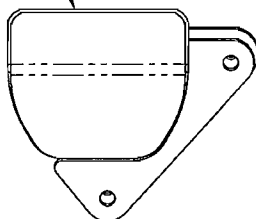
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4308-041	STEP, LH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)

APPLY BLACK
ANTI-SKID ON TOP
SURFACE TO BOTTOM
OF TOP RADIUS



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT

WITHOUT NOTICE
WORK ORDER
NO. ~~70100~~

PRELIMINARY ISSUE

Rev. PAZ 11.01.13

D4308-041 STEP, LH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-041" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lb
- 8) WELDING: PER DART QSI 004

PAZ	ADD WING-WALK, VENT HOLE	CP	11.01.13
A	NEW ISSUE	CP	10.12.17
REV.	DESCRIPTION	BY	DATE
DESIGN	CP		
DRAWN	CP		
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	10.12.17		

DART AEROSPACE LTD
HAWKESBURY, ONTARIO, CANADA

DRAWING NO.
D4308

TITLE
STEP, CREW

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REV. 11.01.13

SHEET 1 OF 3

SCALE

NTS

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

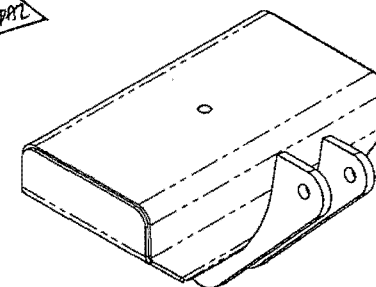
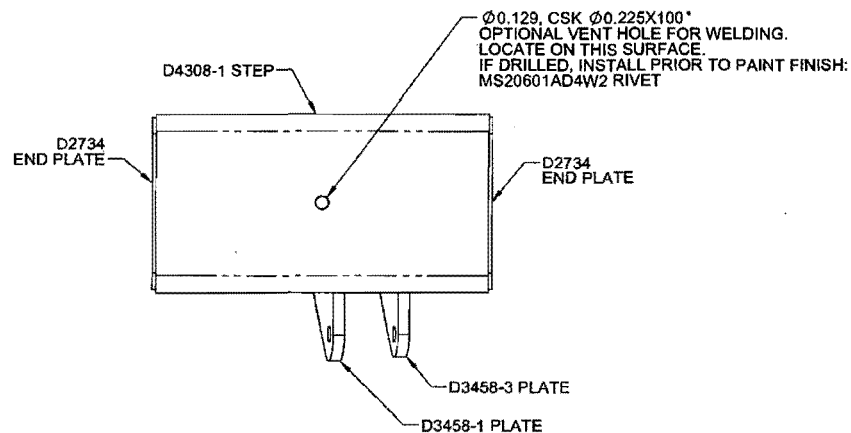
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

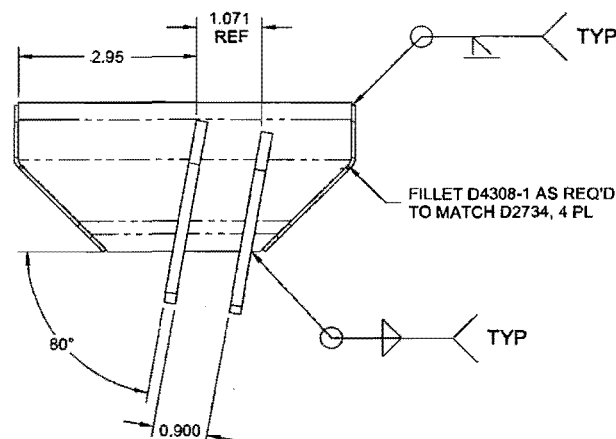
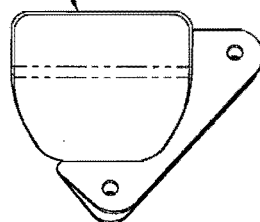
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM	QTY -042	P/N	DESCRIPTION
1	X	D4308-042	STEP, RH CREW
2	1	D4308-1	STEP
3	2	D2734	END PLATE
4	1	D3458-1	PLATE
5	1	D3458-3	PLATE
6	1	MS20601AD4W2	RIVET (OPTIONAL)



APPLY BLACK
ANTI-SKID ON TOP
SURFACE TO BOTTOM
OF TOP RADIUS



D4308-042 STEP, RH CREW

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT "WHITE" (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4308-042" AND B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.47 lbs
- 8) WELDING: PER DART QSI 004

PRELIMINARY ISSUE

Ra PAZ 11.01.13

DESIGN	88	DART AEROSPACE LTD	
DRAWN	88	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4308	SHEET 2 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
DATE	10.12.17	<small>COPYRIGHT © 2016 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR REPRODUCED IN ANY FORM OR BY ANY MEANS WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

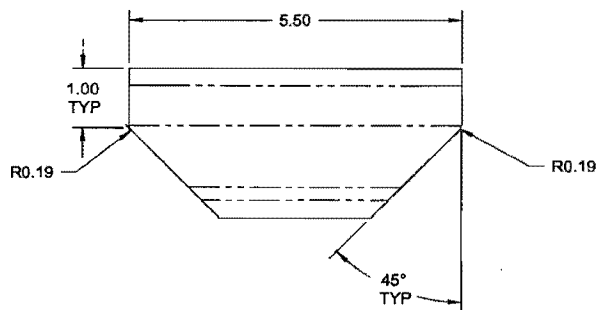
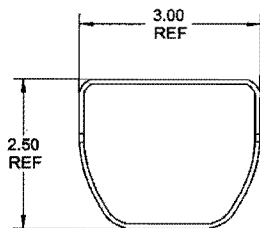
W/O:		WORK ORDER CHANGES					
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D4308-1 STEP

u1070109
10212

PRELIMINARY ISSUE

REV PAZ CP 11.01.13

NOTES:

- 1) MATERIAL: MAKE FROM D2622 EXTRUSION
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.33 lbs

DESIGN	<i>DP</i>	DART AEROSPACE LTD	
DRAWN	<i>DP</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. <i>A</i>
MFG. APPR.		D4308	SHEET 3 OF 3
APPROVED		TITLE	SCALE
DE APPR.		STEP, CREW	NTS
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

REFERENCE ONLY

DART AEROSPACE USA, INC.

IIN-D206-628

Page 19 of 19

5.4 CREW STEP PARTS LIST

Qty -015	Qty -016	Qty -025	Qty -026	Qty -035	Qty -036	Part Number	Description
X			1			D206-628-015	CREW STEP, LH 206A/B
	X					D206-628-016	CREW STEP, RH 206A/B
		X				D206-628-025	CREW STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-026	CREW STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-035	CREW STEP, LH 407
					X	D206-628-036	CREW STEP, RH 407
				2	2	D2731-3RG	MOUNTING LUG
2	2	2	2			D2731-7RG	MOUNTING LUG
				2	2	D3394-1RG	MOUNTING LUG
2	2	2	2			D3394-3RG	MOUNTING LUG
		1		1		D4308-041	CREW STEP, LH
			1		1	D4308-042	CREW STEP, RH
2	2	2	2	2	2	D4309-1	BUSHING
1						D4357-041	CREW STEP, LH
	1					D4357-042	CREW STEP, RH
		4	4			AN4-11A	BOLT
4	4	4	4	4	4	AN4-12A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

5.5 MAINTENANCE STEP PARTS LIST

Qty -017	Qty -018	Qty -027	Qty -028	Qty -037	Qty -038	Part Number	Description
X						D206-628-017	MAINTENANCE STEP, LH 206A/B
	X					D206-628-018	MAINTENANCE STEP, RH 206A/B
		X				D206-628-027	MAINTENANCE STEP, LH 206L/L-1/L-3/L-4
			X			D206-628-028	MAINTENANCE STEP, RH 206L/L-1/L-3/L-4
				X		D206-628-037	MAINTENANCE STEP, LH 407
					X	D206-628-038	MAINTENANCE STEP, RH 407
2	2			2	2	D2731-3RG	MOUNTING LUG
		2	2			D2731-7RG	MOUNTING LUG
2	2			2	2	D3394-1RG	MOUNTING LUG
		2	2			D3394-3RG	MOUNTING LUG
2	2	2	2	2	2	D4309-1	BUSHING
		1		1		D4342-041	MAINTENANCE STEP, LH
			1		1	D4342-042	MAINTENANCE STEP, RH
1						D4358-041	MAINTENANCE STEP, LH
	1					D4358-042	MAINTENANCE STEP, RH
4	4	4	4	4	4	AN4-12A	BOLT
		4	4			AN4-13A	BOLT
2	2	2	2	2	2	AN4-15A	BOLT
6	6	6	6	6	6	MS21042-4	NUT
6	6	6	6	6	6	NAS1149D0463J	WASHER (AN960JD416)

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Revision: G

Date: 11.02.25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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